

Work Order ID 70148-259/11

Monday, May 30, 2011 11:23:39 AM



Page 1

Item ID: D3197-041

Revision ID:

Item Name: Bar Assembly

Start Date: 5/30/2011 Start Qty: 4.00

Required Date: 6/10/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: MF

QC:

Date: 11-05-30 Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3197

Rev B

109

0.00



Bandsaw

Jeaspa Bandsaw

HAND SAW

Memo

Cut blanks 29 125" long

0.00

110

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Face ends to length per dwg D3197 2-Machine D3197-1 as per Folio FA340 and Dwg D3197 3-Deburr

0.00

120

0.00



QC

Quality Control

QC2- Inspect parts off machine 1-AIT/ABJ

Memo

0.00

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Page 2

Item ID: D3197-041

Accept

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Setup Start

Stop

Start Date: 5/30/2011 Start Qty: 4.00

Required Date: 6/10/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Lathe Conv

Conventional Lathe

CONVENTIONAL LATHE

Memo

Chamfer as per Dwg D3197

0.00

0.00

32 11/06/02

6

140



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

21 11/06/02

6

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

6 11/06/02

Work Order ID 70148

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Accept



Setup Start



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Stop



Start Date: 5/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Grey Sandtex(Ref:4.3 5.6) per QSI005 4.3

0.00



Powdercoat

Memo

START TIME

FINISH TIME.

0.00

OVEN TEMPERATURE.

Powder Coating

170

QC:3-Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3197-041 as per Dwg D3197

Exp m/11/06/02

6 & 11-6-2

Ep 11/06/08 @

M115128

9:30

10:00

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Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 5/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- inspect part completeness to step on W/O

0.00

Subtotal

(+40)



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location *260*

0.00

11/6/8 (+25)



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

11/6/9



QC

Memo

0.00

Quality Control

MF 11-06-08

Picklist Print

Monday, May 30, 2011 11:23:36 AM

Page 1

Work Order ID: 70148

Parent Item: D3197-041

Parent Item Name: Bar Assembly



Start Date: 5/30/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* AN960JD10 Washer	NAS1149D0463J	Purchased				180	Each	0.0000	6	24		5/11/06/06	
* D2690-5 Lanyard Assembly		Manufactured	No			180	Each	11.0000	2	8		5/11/06/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				11				B70390 (1x)	
				66820				11					
D3242-1 Tag		Manufactured	No			180	Each	4.0000	2	8		5/11/06/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST044				4				B70154 (8x)	
				65390				4					
D3489-3-200 PIP PIN		Manufactured	No			180	Each	9.0000	2	8		5/11/06/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				9				5	
				68563				9					

Picklist Print

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Work Order ID: 70148

Parent Item: D3197-041

Parent Item Name: Bar Assembly



Start Date: 5/30/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

M7075T73R1 000

Purchased

No

180

F

30 8650

2.42

12.1



7075-T73 Rd Bar 1 00



SL 11/06/02

Location

Loc Qty

Loc Code

MA1012

30 865

115165

2.7

116405

4.54

116604

2.25

116835

12

116962

9.375

7.68
4.81

MS2104213

Purchased

No

180

Each

2.119.000

2

8



Nut



EP 11/06/06

Location

Loc Qty

Loc Code

ST300

2119

116391

11

116540

142

116549

766

117441

800

117601

400

8

MS27039-1-24

Purchased

No

100

Each

122.0000

2

8



Screw



EP 11/06/06

Location

Loc Qty

Loc Code

ST292

122

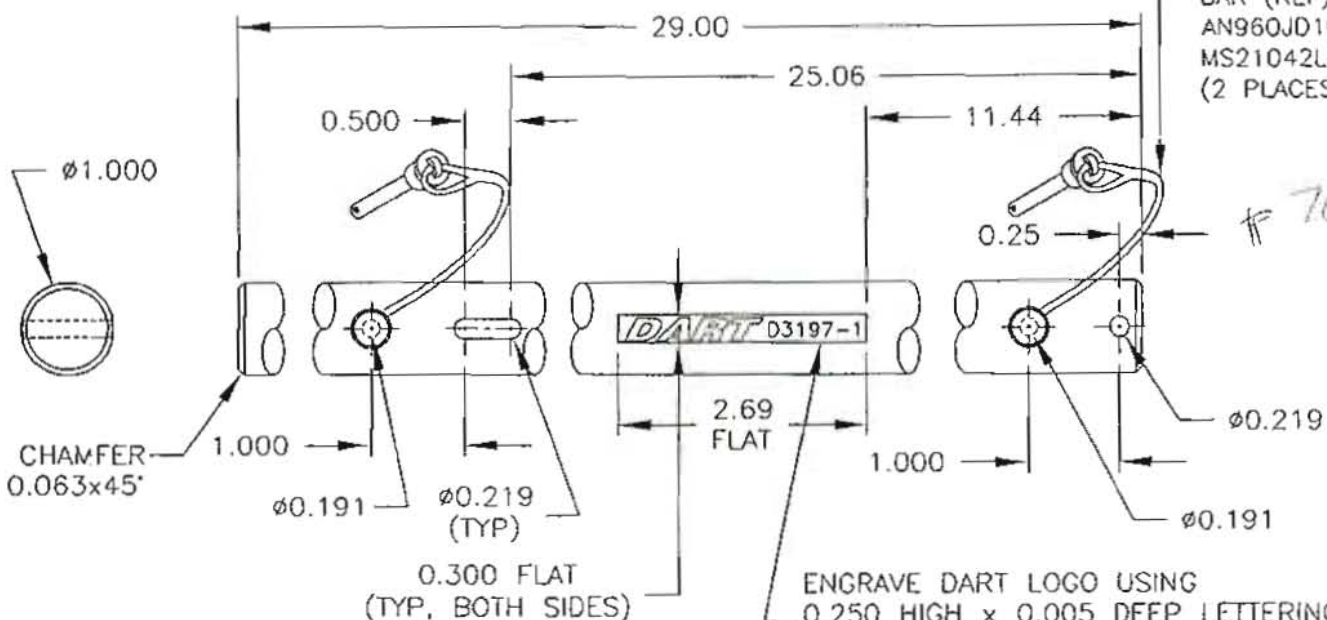
100151

122

8

6. N. 7. 1.

f 70148



ENGRAVE DART LOGO USING
0.250 HIGH x 0.005 DEEP LETTERING
AND P/N USING 0.150 HIGH x 0.005
DEEP LETTERING ON BOTH SIDES

1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) Ø1.000 O.D.
(REF DART SPEC. M7075T73R1.000)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	CP	APPROVED	CP	DRAWING NO.	REV. B
DATE	06.01.10	TITLE	SCALE	D3197	SHEET 1 OF 1
A	03.07.01	BAR	1:1	NEW ISSUE	
B	06.01.10	CHG PIP PIN: ADD D3242-1 TAG			

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